

Date: Thursday, 2/23/2006 10:24:30 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STA 155 BRACKET					
Job Number	: 25930		Part Number	: D28042					
Estimate Number	: 11040		Drawing Number	: D2804 REV B					
P.O. Number	: N/A		Project Number	: N/A					
This Issue	: 2/23/2006	S.O. No.	: N/A		Drawing Revision	: B			
Prsh Rev.	: NC		Type	: SMALL /MED FAB		Material	: N/A		
First Issue	: N/A					Due Date	: 3/22/2006		
Previous Run	: 25714					Qty:	10	Um:	Each
Written By	<u>See COMMENT Below</u>								
Checked & Approved By	<u>JF 06.02.23</u>								
Comment	: Est. A00.11.06		New Issue EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"		
		Comment: Qty.: 0.7875 f(s)/Unit Total : 7.8750 f(s) 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50"	Batch: M100046	J.F. 06/03/12 10
2.0	BAND SAW	BAND SAW		
		Comment: BAND SAW Cut blanks per template DT8534		J.F. 06/03/12 10
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA103		J.F. 06/03/12 10
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		J.F. 06/03/12 10
5.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK		J.F. 06.03.12 10
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & Deburr		J.F. 06/03/12 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/03/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:24:30 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 25930

Part Number: D28042

Job Number:



Seq. #:	Machine Or Operation:	Description :	
7.0	QC5	INSPECT WORK TO CURRENT STEP	
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
9.0	PACKAGING 1	PACKAGING RESOURCE #1	
10.0	DC	DOCUMENT CONTROL	

Comment: INSPECT WORK TO CURRENT STEP      *BL*      *06/03/12*      *10*

Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1      *SAD*      *06:03:14*      *DO*

Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: *G A*      *SB*      *06/03/14*      *10*

Comment: DOCUMENT CONTROL  
Inspection Level 21      *DO*      *06/03/15*      *10*

Job Completion



*U 06/03/14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25930
Description: STA 155 Bracket	Part Number:	D2804-2
Inspection Dwg: D2804 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.127"				
0.125	+/-0.010	0.123"				
R0.125	+/-0.010	R0.125"				
0.250	+/-0.010	,249"				
0.250	+0.000/-0.005	,245"				
0.875	+0.000/-0.001	,874"				
R0.062	+/-0.010	0.062" R				
Ø0.757	+0.005/-0.000	Ø.760"				
R0.625	+/-0.010	R0.625"				
12.304	+/-0.005	12.304"				
Ø0.507	+0.000/-0.001	Ø.506"				
0.437	+0.000/-0.001	,437"				
0.608	+0.000/-0.001	,608"				
Ø0.191	+0.005/-0.000	Ø.192"				
1.420	+0.001/-0.001	1.421"				
0.250 deep	+/-0.010	,244"				
6.933	+/-0.005	6.936"				
7.578	+/-0.005	7.579"				
0.500	+/-0.010	,500"				

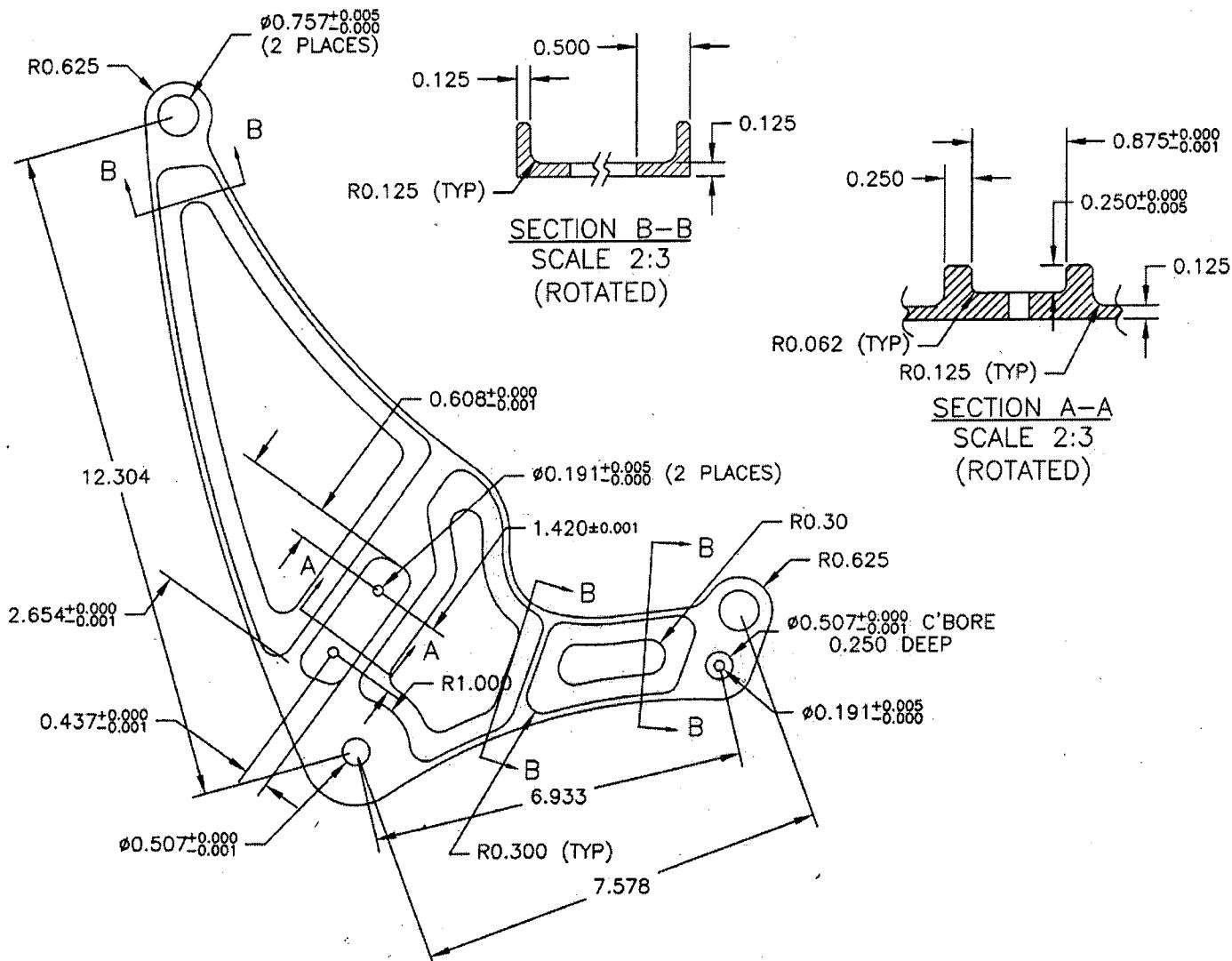
Measured by:	J.F.	Audited by:	J.G.	Prototype Approval:	N/A
Date:	06/03/11	Date:	06/03/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

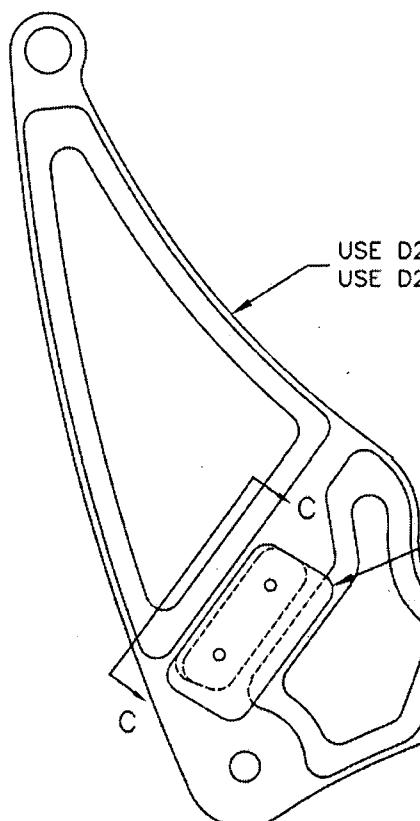
05.03.11 *[Signature]***D2804-1 BRACKET (SHOWN), D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
  - 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK TO AMENDMENT
  - 3) DEBURR TO LEAVE R0.030 – 0.063 ON ALL EDGES
  - 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNCONTROLLED COPY  
WITHOUT NOTICE  
WORK ORDER NO. 25930

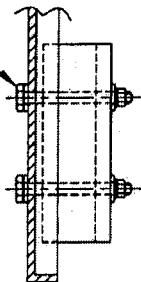
SHOP COPY  
RETURN TO  
ENGINEERING

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2804
DATE 04.11.22	TITLE STA 155 BRACKET	REV. B SHEET 2 OF 2 SCALE 1:3



AN3C16A BOLT (1)  
NAS1515H3 WASHER (2)  
MS21043-3 NUT (1)  
INSTALL BOLT WITH LPS-3 CORROSION  
INHIBITOR (ENSURE NO LPS-3 ON THREADS)  
(2 PLACES)



SECTION C-C  
SCALE 1:3  
(ROTATED)

USE D2805-1 FOR D2804-041/-043  
USE D2805-2 FOR D2804-042/-044  
USE D2805-3 FOR D2804-043  
USE D2805-4 FOR D2804-044  
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO  
POWDER COAT

SHOP COPY

RETURN TO

ENGINEERING

**RELEASED**  
05-03-11 UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 25930

D2804-041/-043 BRACKET ASS'Y (SHOWN),  
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)  
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3

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